

Work Order ID 67662

Tuesday, March 29, 2011 8:23:48 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4195-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Mixer Box Assembly

Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 2.00



Customer:



Reference:

Handwritten: 11-03-29

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4195

Handwritten: PAS 11-06-07

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 11-06-08

Handwritten: 2

Handwritten: 0

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble step 1 to 8 as per dwg
2- Assemble step 9 as per dwg
3- Assemble step 10 ***DO NOT INSTALL COVER, IT NEEDS TO BE INSPECTED BEFORE CLOSING***

Handwritten: 11-06-08

Handwritten: 2

Handwritten: 0

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten: -inspector to PAS Day only

Handwritten: 06/08

Handwritten: (R2)

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Item ID: D4195-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Mixer Box Assembly

Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Memo 1- Install cover per step 10 as per dwg 2- Assemble step 11 to 12 as per dwg	0.00							
Small Fab		0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: <u>9296</u>	0.00							
Packaging	Memo	0.00							






*Inv 11.06.08**2 0**- inspector to pass**Dy only**8 ulowlor (K2)**92334**11.06.10*



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Item ID: D4195-041 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Mixer Box Assembly
Start Date: 3/30/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 4/7/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL
EFFECTIVE 4/6/11 AUTH cr
RELEASED _____ DATE _____

Picklist Print

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly








Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.20 new issue DD verf:JLM
IPP REV B 11-02-03 UPDATE TO PA3 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4184-041 ✓  Main Case Assembly		Manufactured	No			100	Each	0.0000	1	2			B67495
✓ D4184-3  Main Case Cover		Manufactured	No			100	Each	0.0000	1	2			B66434
✓ D4184-9  Main Case Solenoid Cover		Manufactured	No			100	Each	0.0000	1	2			B65229
✓ D4186-041  Eccentric Assembly		Manufactured	No			100	Each	0.0000	1	2			B65231
✓ D4187-1  Bearing		Manufactured	No			100	Each	0.0000	1	2			B63303
✓ D4187-3  Bearing		Manufactured	No			100	Each	0.0000	1	2			B63307
✓ D4187-5  Bearing		Manufactured	No			100	Each	0.0000	1	2			B65232
✓ D4187-7  Bearing		Manufactured	No			100	Each	0.0000	1	2			B65233

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Work Order ID: 67662

Parent Item: D4195-041





















Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

D4188-9	Manufactured	No	100	Each	0.0000	1	2	
								
Spring, Plunger								B63365
D4189-041	Manufactured	No	100	Each	0.0000	1	2	
								
Pivot Assembly								B65235
D4190-041	Manufactured	No	100	Each	0.0000	1	2	
								B65495
External Bellcrank Assembly								
D4193-041	Manufactured	No	100	Each	0.0000	1	2	
								B65236
RVDT Adapter								
D4194-1	Manufactured	No	100	Each	0.0000	1	2	
								B65237
Plunger Stem								
D4194-3	Manufactured	No	100	Each	0.0000	1	2	
								B65238
Plunger Bumper								
D4194-5	Manufactured	No	100	Each	0.0000	1	2	
								B65239
Plunger Bushing								
D4196-041	Manufactured	No		Each	0.0000		2	
								B66213
Solenoid Assembly								
D4197-1	Manufactured	No	100	Each	0.0000	1	2	
								At Eagle 9/0104338
Rotary Variable Displacement Transducer (LVDT)								B/N 63708
D4199-1	Manufactured	No	100	Each	0.0000	1	2	
								B65241
Spacer								

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Work Order ID: 67662

Parent Item: D4195-041





















Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

✓ D4199-3	Manufactured	No	100	Each	0.0000	1	2		
								B65242	
Spacer									
D4200-1	Manufactured	No	100	Each	0.0000	2	4		
								B65243	
Pin									
D4204-1	Manufactured	No	100	Each	0.0000	1	2		
								B64100	
Plunger Cover									
✓ D4205-1	Manufactured	No	100	Each	0.0000	1	2		
								B65245	
Solenoid Spacer									
D4206-041	Manufactured	No	100	Each	0.0000	1	2		
								B#63837	
Diode Assembly									
D4208-1	Manufactured	No	100	Each	0.0000	2	4		
								B65245	
Insulator								63396	
D4208-3	Manufactured	No	100	Each	0.0000	2	4		
								B63395	
Insulator									
D4210-1	Manufactured	No	100	Each	0.0000	1	2		
								B65377	
Idle Stop Set Screw									
D4210-3	Manufactured	No	100	Each	0.0000	1	2		
								B65378	
Max Stop Set Screw									
D4210-5	Manufactured	No	100	Each	0.0000	1	2		
								B65379	
Pivot Rest Set Screw									

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

D4210-9 Manufactured No Each 0.0000



Screw



2
B67122 2K *[Signature]*
11-05-31

D4329-041 Manufactured No Each 0.0000



Internal Bellcrank Assembly



2
66214

~~MS210421-08~~ MS210421-08 Purchased No 100 Each 371.0000 1 2



Nut



~~117087~~ *[Signature]*
m116391 *[Signature]*

Location Loc Qty Loc Code

ST300 371

116823 371

MS24665-136 Purchased No 100 Each 104.0000 1 2



Cotter Pins



Location Loc Qty Loc Code

ST308 104

2421 104

2421

MS24677-1 Purchased No 100 Each 35.0000 4 8



Bolt



Location Loc Qty Loc Code

ST309 35

116074 35

~~116075~~ m116067

MS24677-7 Purchased No 100 Each 25.0000 1 2



Bolt



Location Loc Qty Loc Code

ST309 25

116059 25

116055

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

MS24677-10

Purchased

No

100

Each

15.0000

1

2



Bolt

Location

Loc Qty

Loc Code

ST309

15

116074

15

116074

MS24677-15

Purchased

No

100

Each

40.0000

8

16



Bolt

Location

Loc Qty

Loc Code

ST309

40

116038

5

116120

15

116583

20

116583

MS24677-17

Purchased

No

100

Each

18.0000

1

2



Bolt

Location

Loc Qty

Loc Code

ST309

18

116059

18

116059

MS35333-37

Purchased

No

100

Each

1,000.000

1

2



Lock Washer

Location

Loc Qty

Loc Code

ST295

1000

116067

1000

116067

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

MS35333-38

Purchased

No

100

Each

78.0000

1

2



LOCK WASHER

Location

Loc Qty

Loc Code

ST295

78

107063

78

167063

NAS1149DN432J

Purchased

No

100

Each

118.0000

5

10



Washer

Location

Loc Qty

Loc Code

ST298

118

116702

100

11735

18

11735

NAS1149D0332J

Purchased

No

100

Each

2,302.000

2

4



Washer

Location

Loc Qty

Loc Code

FP-B

160

117010

160

ST297

2000

117087

2000

ST298

142

117010

142

117010

NAS1149D0432J

Purchased

No

100

Each

272.0000

2

4



WASHER

Location

Loc Qty

Loc Code

ST298

272

114718

72

116583

200

114718

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149CN832R

Purchased

No

100

Each

200.0000

3

6



Washer

Location

Loc Qty

Loc Code

ST297

200

116038

200

116038

~~NAS1149DN832J~~

Purchased

No

100

Each

204.0000

1

2



WASHER

NAS1149D0332S

9-11-04-07

Location

Loc Qty

Loc Code

ST298

204

116513

19

116857

185

117010

h

116857

NAS509-06

Purchased

No

100

Each

10.0000

1

2



Nut

Location

Loc Qty

Loc Code

ST280

10

116067

10

116067

NAS509-08

Purchased

No

100

Each

10.0000

1

2



Nut

Location

Loc Qty

Loc Code

ST280

10

116067

10

116067

11/3/30

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Work Order ID: 67662

Parent Item: D4195-041

Parent Item Name: Mixer Box Assembly

Start Date: 3/30/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

NAS509-3 Purchased No 100 Each 12.0000 1 2



Nut

Location	Loc Qty	Loc Code
ST280	12	
115006	4	
116583	8	

115006

NAS509-4 Purchased No 100 Each 10.0000 2 4



Nut

Location	Loc Qty	Loc Code
ST280	10	
116038	5	
116583	5	

116038

NAS509-9C Purchased No 100 Each 8.0000 1 2



Nut

Location	Loc Qty	Loc Code
ST280	8	
116038	4	
116583	4	

116583

2x P4386-1 B68495 Jw/11.05.31

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ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION	SHEET REF.
1	X	D4195-041	MIXER BOX ASSEMBLY	13
2	1	D4184-041	MAIN CASE ASSEMBLY	2
3	1	D4184-3	MAIN CASE COVER	10
4	1	D4184-9	MAIN CASE SOLENOID COVER	11
5	1	D4186-041	ECCENTRIC	8
6	1	D4187-1	BEARING	2
7	1	D4187-3	BEARING	10
8	1	D4187-5	BEARING	2
9	1	D4187-7	BEARING	10
10	1	D4188-9	PLUNGER SPRING	3
11	1	D4189-041	PIVOT ASSEMBLY	6
12	1	D4190-041	EXTERNAL BELLCRANK	9
13	1	D4193-041	RVDI ADAPTER ASSEMBLY	12
14	1	D4194-1	PLUNGER STEM	3
15	1	D4194-3	PLUNGER BUMPER	3
16	1	D4194-5	PLUNGER BUSHING	3
17	1	D4196-7	NUT	5
18	1	D4196-041	SOLENOID ASSEMBLY	5
19	1	D4197-1	RVDI	12
20	1	D4199-1	SPACER	9
21	1	D4199-3	SPACER	9
22	2	D4200-1	PIN	9
23	1	D4204-1	PLUNGER COVER	3
24	1	D4205-1	SOLENOID SPACER	5
25	1	D4206-041	DIODE ASSEMBLY	7

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION	SHEET REF.
26	2	D4208-1	INSULATOR	7
27	2	D4208-3	INSULATOR	7
28	1	D4210-1	IDLE STOP SET SCREW	4
29	1	D4210-3	MAX STOP SET SCREW	4
30	1	D4210-5	PIVOT REST SET SCREW	4
31	1	D4210-9	BOLT	12
32	1	D4329-041	INTERNAL BELLCRANK ASSEMBLY	9
33	2	D4386-1	O-RING	2, 12
34	1	MS21042L3	NUT	8
35	1	MS24665-136	COTTER PIN	3
36	4	MS24677-3	BOLT	11
37	1	MS24677-10	BOLT	7
38	8	MS24677-15	BOLT	11, 12
39	1	MS24677-17	BOLT	7
40	1	MS35333-37	LOCKWASHER	7
41	1	MS35333-38	LOCKWASHER	7
42	5	NAS1149DN432J	WASHER	11, 12
43	2	NAS1149D0332J	WASHER	3, 4
44	2	NAS1149D0432J	WASHER	4
45	3	NAS1149CN832R	WASHER	12
46	1	NAS1149D0332J	WASHER	8
47	1	NAS509-06	NUT	7
48	1	NAS509-08	NUT	7
49	1	NAS509-3	NUT	4
50	2	NAS509-4	NUT	4

D4195-041 MIXER BOX ASSEMBLY

PRELIMINARY ISSUE

10.10.27

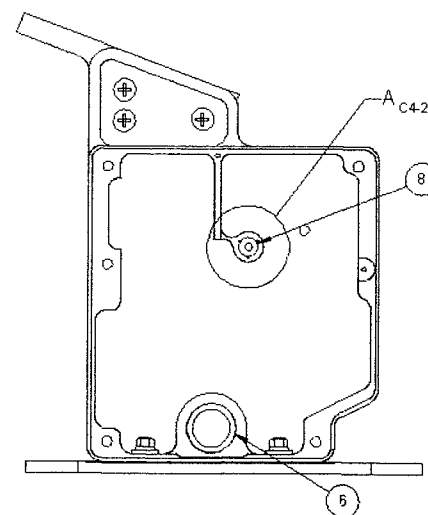
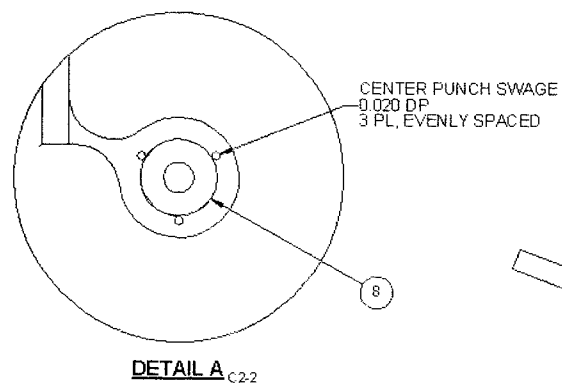
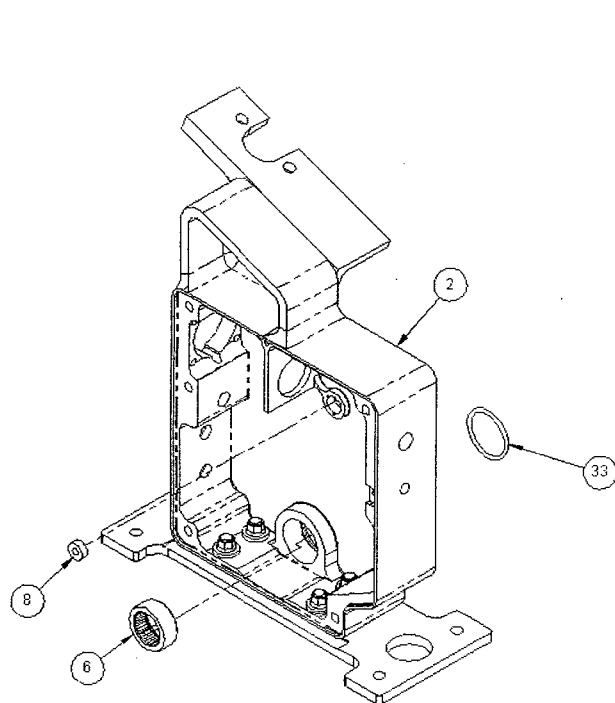
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: N/A

PA5	NEW ISSUE	BY	10.10.04
REV.	DESCRIPTION	DATE	
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4195	REV. PA5 SHEET 1 OF 13
TITLE MIXER BOX	SCALE NTS

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**D4195-041 MIXER BOX
ASSEMBLY STEP 1**

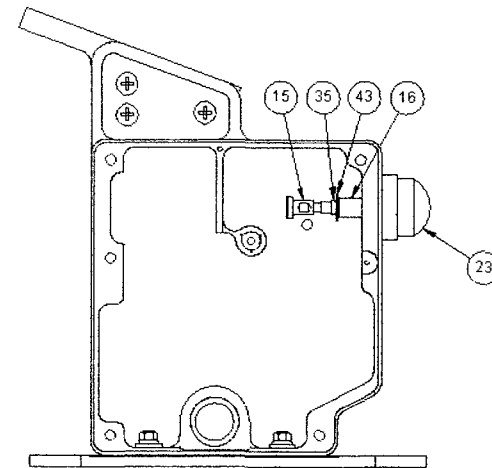
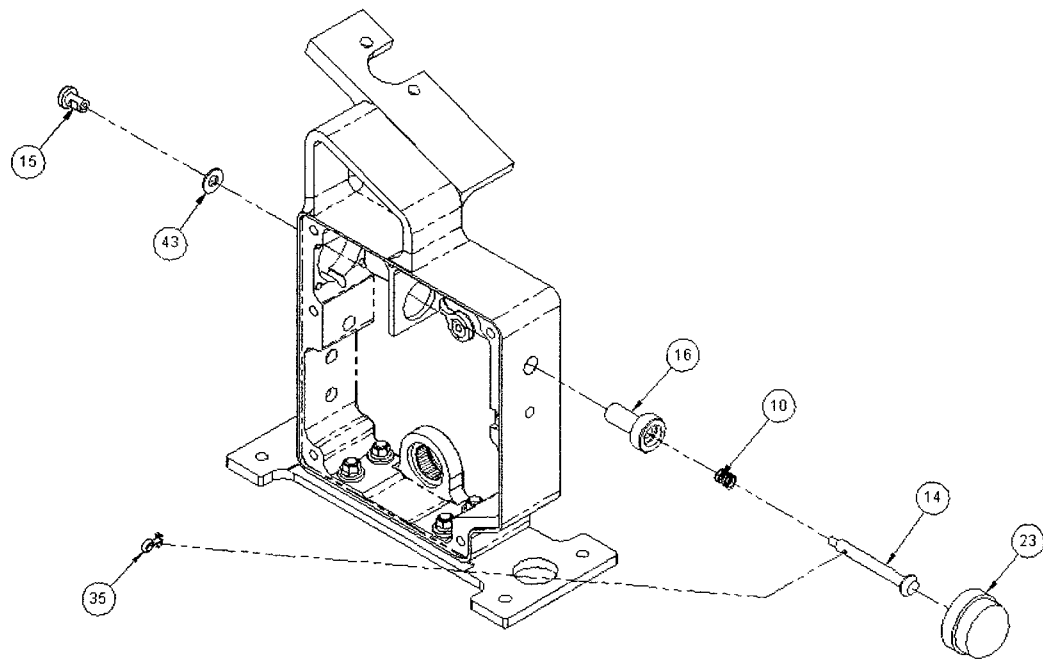
PRELIMINARY ISSUE

10.10.27

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4195	REV. PA5
MFG. APPR.			SHEET 2 OF 13
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
DATE	10.10.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS REPRODUCED IN CONFIDENTIALITY AND IS SUBJECT TO THE EXPORTATION OF THE TITLE AND TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4195-041 MIXER BOX
ASSEMBLY STEP 2**

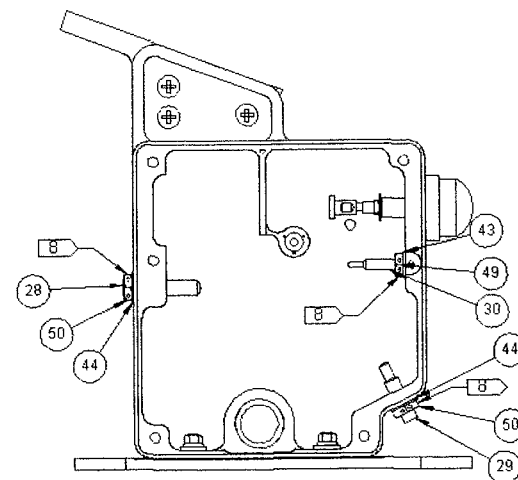
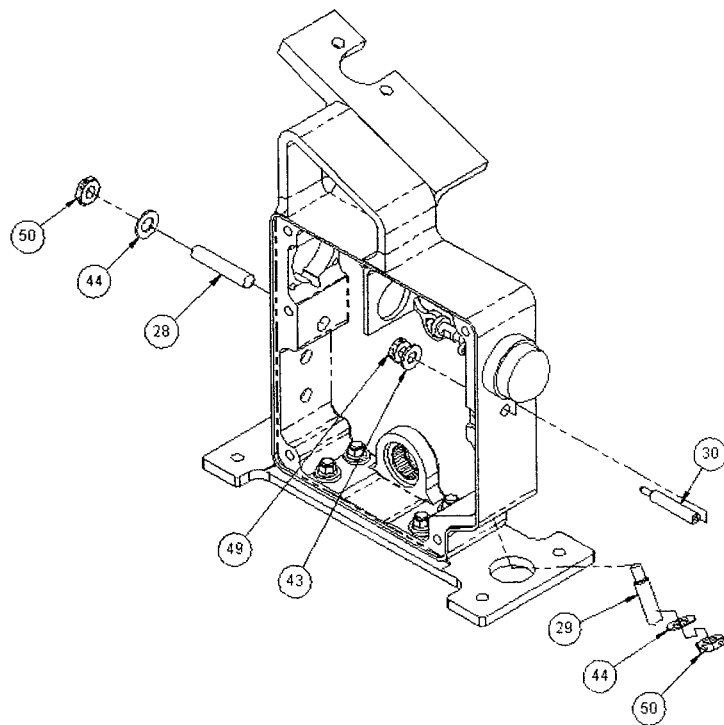
PRELIMINARY ISSUE

10.10.27

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4195	REV. PA5
MFG. APPR.		SHEET 3 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
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**D4195-041 MIXER BOX
ASSEMBLY STEP 3**

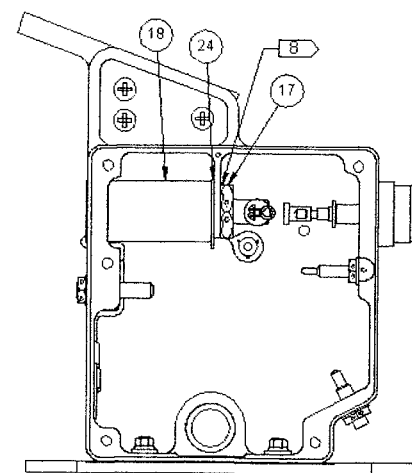
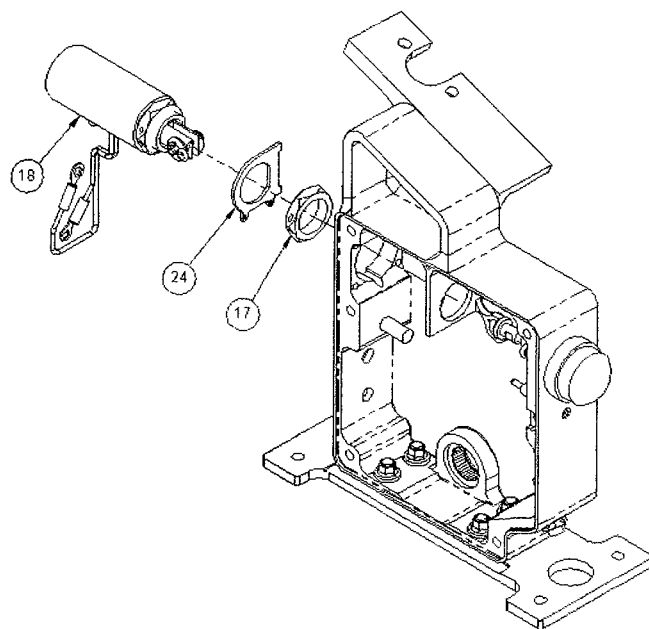
PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) LOCKWIRE NUTS TO CASE PER MS33540

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMMESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4195	SHEET 4 OF 13
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
DATE	10.10.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT THE TITLE NOTED BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4195-041 MIXER BOX
ASSEMBLY STEP 4

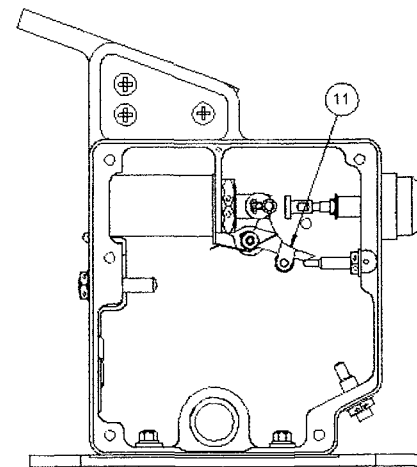
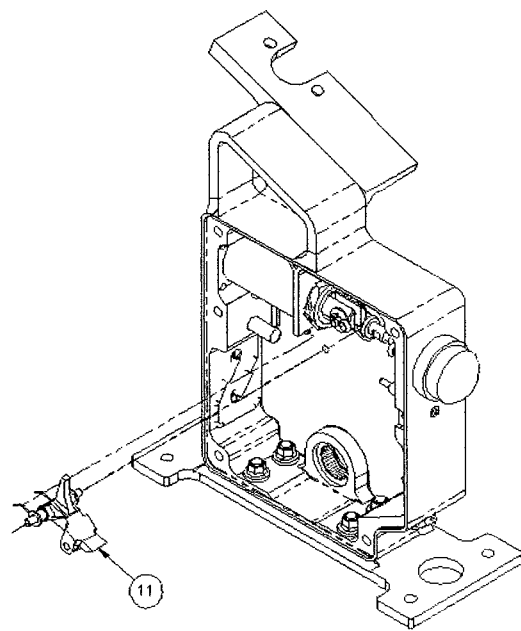
PRELIMINARY ISSUE

10.10.27

NOTES:

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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) LOCK WIRE NUT TO CASE PER MS33540

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4195	REV. PA5
MFG. APPR.		SHEET 5 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
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D4195-041 MIXER BOX
ASSEMBLY STEP 5

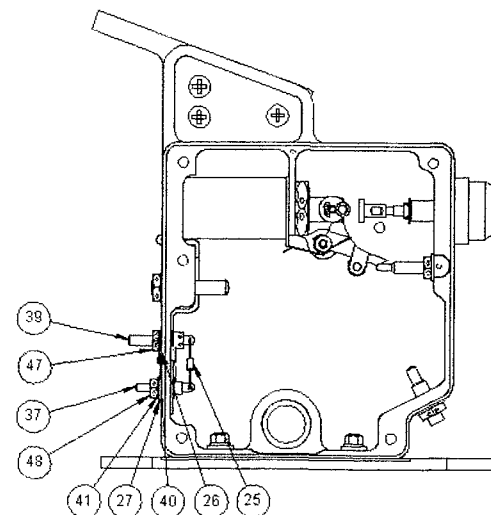
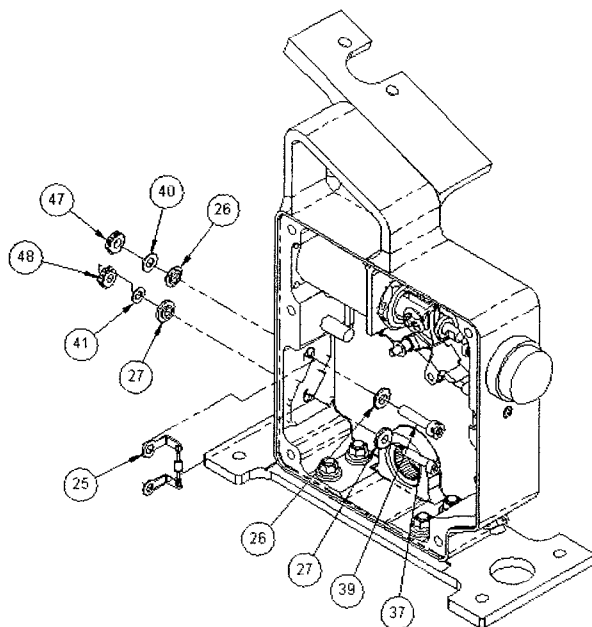
PRELIMINARY ISSUE

10.10.27

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4195	SHEET 6 OF 13
APPROVED		TITLE	SCALE
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**D4195-041 MIXER BOX
ASSEMBLY STEP 6**

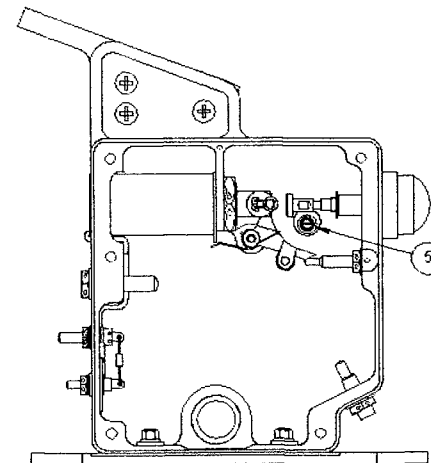
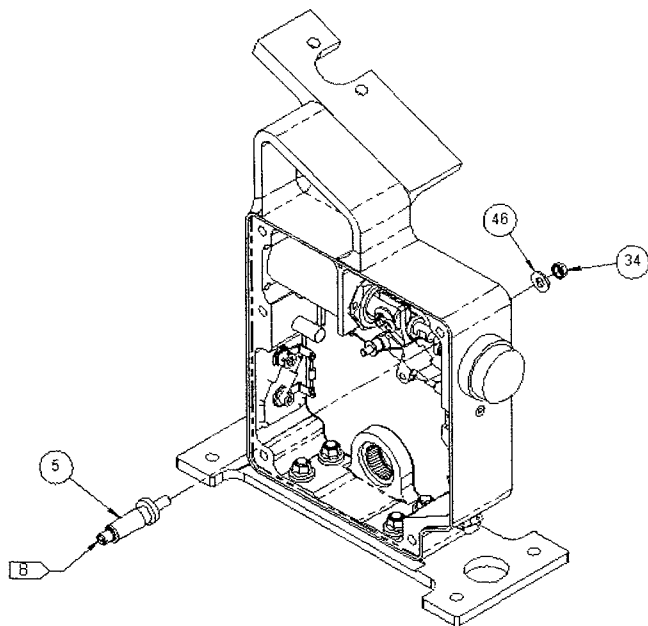
PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

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MFG. APPR.		D4195	SHEET 7 OF 13
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**D4195-041 MIXER BOX
ASSEMBLY STEP 7**

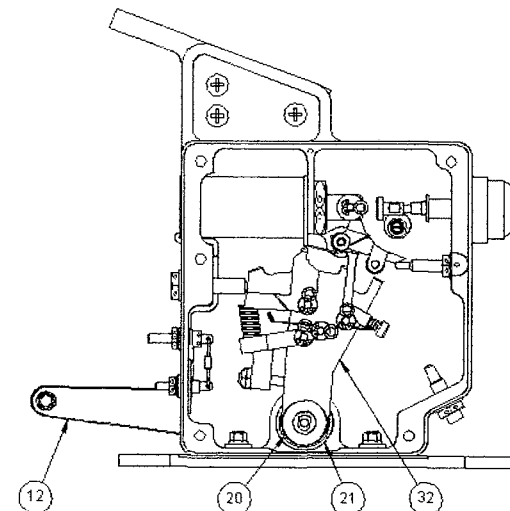
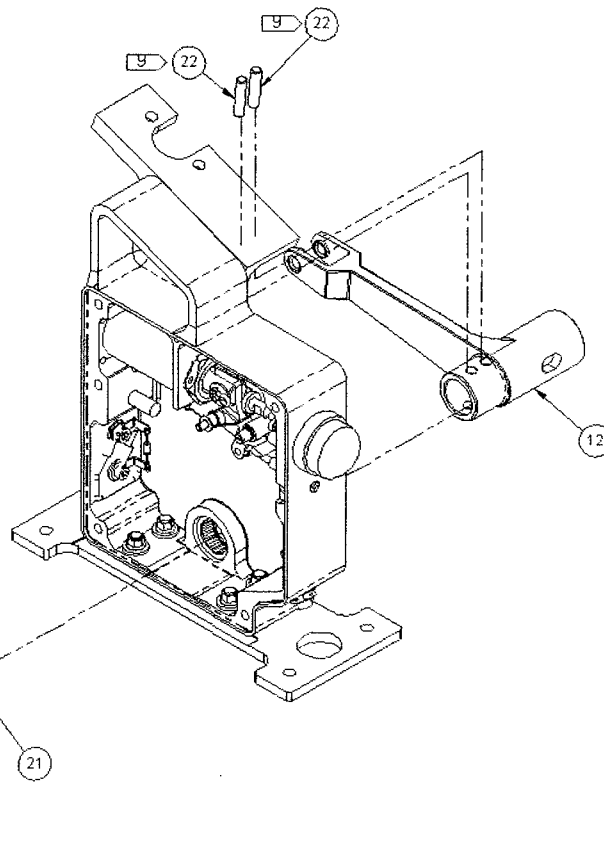
PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) ALIGN FLAT EDGE OF SPACER WITH BOTTOM OF CASE

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MFG. APPR.		D4195	SHEET 8 OF 13
APPROVED		TITLE	SCALE
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**D4195-041 MIXER BOX
ASSEMBLY STEP 8**

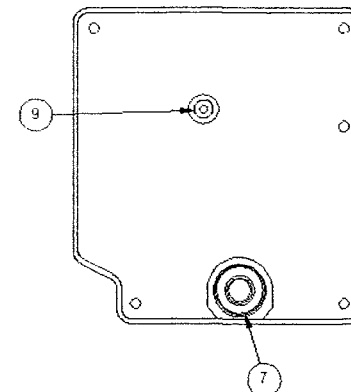
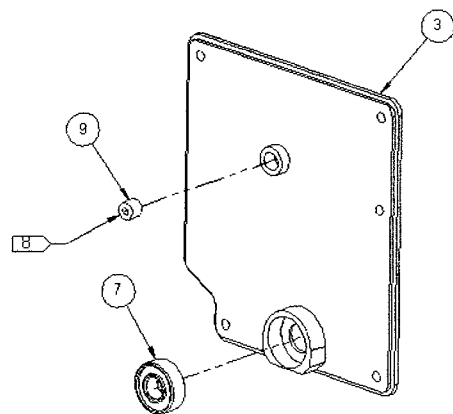
PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) ALIGN FLAT EDGE OF SPACER WITH BOTTOM OF CASE
- 9) CENTER PUNCH SWAGE, BOTH SIDES, AFTER INSTALLATION

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D4195-041 MIXER BOX
ASSEMBLY STEP 9

PRELIMINARY ISSUE

10.10.27

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) CENTER PUNCH SWAGE BEARING SAME AS STEP 01

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MFG. APPR.		D4195	SHEET 10 OF 13
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
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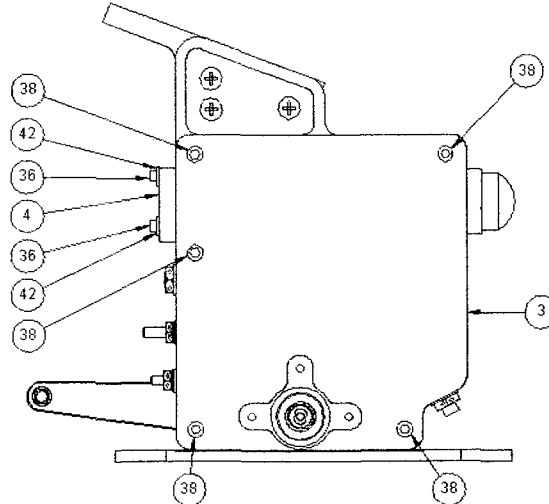
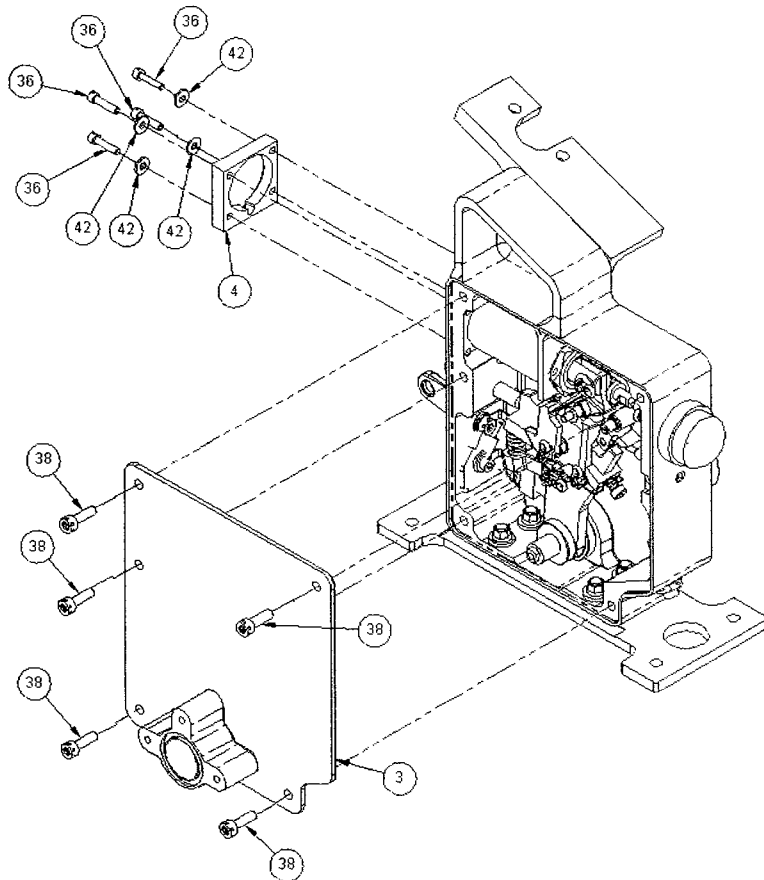
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D4195-041 MIXER BOX
ASSEMBLY STEP 10

PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

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MFG APPR.		SHEET 11 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		MIXER BOX	NTS
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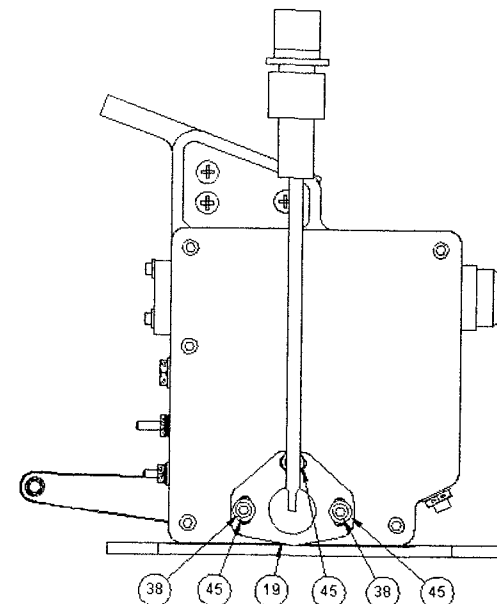
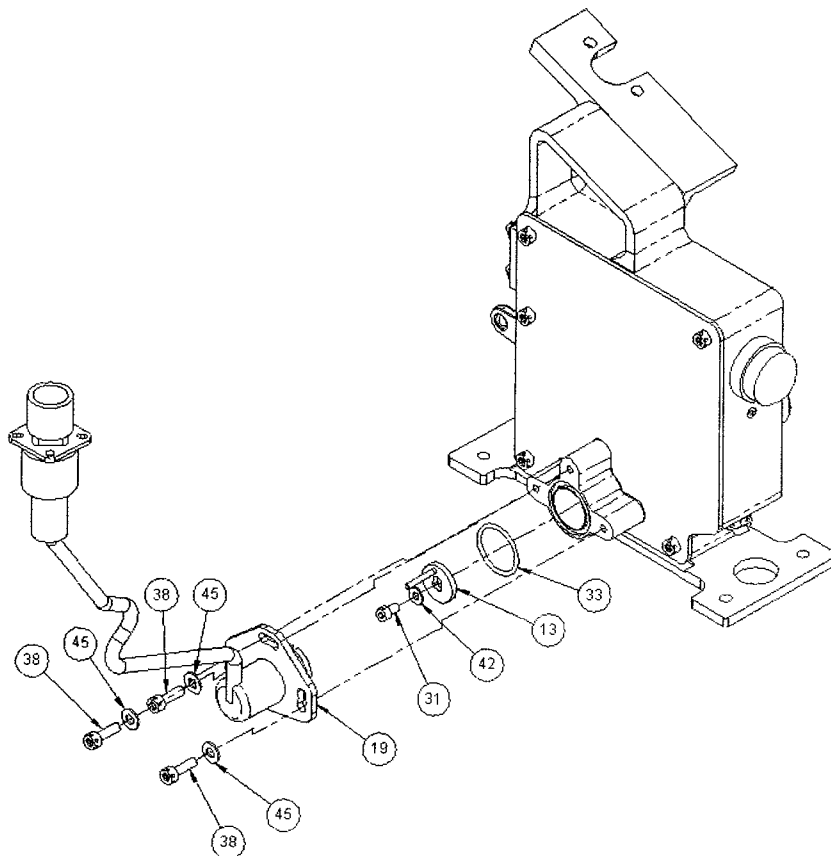
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs

D4195-041 MIXER BOX
ASSEMBLY STEP 11

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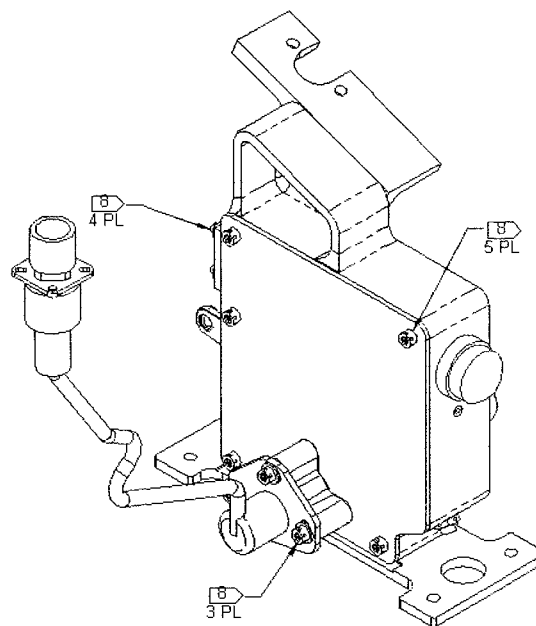
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**D4195-041 MIXER BOX
ASSEMBLY STEP 12**

PRELIMINARY ISSUE

10.10.27

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.61 lbs
- 8) LOCKWIRE SCREWS PER MS33540

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4195	SHEET 13 OF 13
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